

Work Order ID 73244

Friday, August 26, 2011 10:30:02 AM



Page 1

Item ID: DSI 9419-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Energy Attenuating Conversion

Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/26 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9419

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPDSI 9419-011

CHG 000

11-11-24 CL 11-9-1

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11-09-16

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11-11-24 CL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73244

Friday, August 26, 2011 10:30:02 AM



Page 2

Item ID: DSI 9419-011

Accept



Setup Start



Revision ID:

Item Name: Energy Attenuating Conversion

Stop



Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI9419-

011 ☐ Location: _____ ☐ PPP Rev: _____

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Friday, August 26, 2011 10:29:59 AM

Page 1

Work Order ID: 73244



Parent Item: DSI 9419-011

Parent Item Name: Energy Attenuating Conversion

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10- NAS1149D0363J Purchased No



m118077

120 Each 0.0000 9 9



SEP 11-09-06

Washer

D3234-1 Manufactured No



Doubler

Ship Mon/Tues Next 2/22
Dwz 3/1/12

120 Each 8.0000 1 1



B76676 P11/1/12

Location

Loc Qty

Loc Code

ST233

8

70900

2

71140

6

D3234-3 Manufactured No



Doubler

120 Each 6.0000 1 1



SEP 11-09-06

Location

Loc Qty

Loc Code

ST233

6

71141

6

D3808-041 Manufactured No



Seat Rail Assembly

120 Each 1.0000 2 2



SEP 11-09-06

Location

Loc Qty

Loc Code

ST262

1

70906

1

71140

70906 1x

73244 1x

2x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Friday, August 26, 2011 10:30:00 AM

Page 2

Work Order ID: 73244

Parent Item: DSI 9419-011

Parent Item Name: Energy Attenuating Conversion

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3809-1

Manufactured No

120 Each

17.0000

4 4

Sliding Block

Location

Loc Qty

Loc Code

ST084

17

70012

16

70411

1

120 Each

3.0000

D3811-041

Manufactured No

Seat Track Assembly

Location

Loc Qty

Loc Code

ST263

3

70901

1

71009

2

120 Each

5,397.000

MS20426AD4-5

Purchased No

Rivet

Location

Loc Qty

Loc Code

MEZZ

193

6733

193

ST317

5204

6874

5204

120 Each

3,098.000

MS20470AD4-5

Purchased No

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

3098

116893

139

118405

2959

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Friday, August 26, 2011 10:30:00 AM

Page 3

Work Order ID: 73244

Parent Item: DSI 9419-011

Parent Item Name: Energy Attenuating Conversion

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-6 Purchased

No

120

Each

2,013.000

18 18

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2013

117395

502

117887

1511

120

Each

1,749.000

9 9

MS21042L3

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST300

1749

117441

124

117601

400

117885

225

118451

1000

120

Each

90.0000

4 4

MS24694-S153

Purchased

No

Screw

Location

Loc Qty

Loc Code

ST290

120

Each

117.0000

8 8

MS24694-S3

Purchased

No

Screw

Location

Loc Qty

Loc Code

ST289

117

108936

7

117977

10

118354

100

m11274

Friday, August 26, 2011 10:30:00 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O: 73244		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D87945-001 PAR #: N/A Fault Category: Prod Eng NCR: Yes No DQA: Not Date: 11/11/29
11-1032 Resolution: Rework Disposition: Rework QA: N/C Closed Date: 11/11/30

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/21	#100	wrong part on wto parts list Rc 100 PROCESS CONTROL	CP 11.11.28 DS1042	Remove MS24694-5153 + Replace MS24694-5148 M' 108960 Qty 24	SP 21/11 11-11-21	MLH 11.11.24	CP 11.11.28 DS1042	S 11/11/21
			UP 11.11.28	ADD Ex COPY of Bom + W/S ADD copy of Bom for Ref	11/11/29		CP 11.11.28	S 11/11/21

NOTE: Date & initial all entries

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Picklist Print

Page 4

Friday, August 26, 2011 10:30:00 AM

Work Order ID: 73244



Parent Item: DSI 9419-011



Parent Item Name: Energy Attenuating Conversion

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

MS24694-S50

Purchased

No

120

Each

115.0000



Screw



9-9

8. 11-08-06.

Location

Loc Qty

Loc Code

ST289

114

117739

14

118078

100

ST298

1

116900

1

9x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A
AND FLIGHT MANUAL SUPPLEMENT FMS-D350-689 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY **REFERENCE ONLY**

PURPOSE

The purpose of this DSI is to add the D350-689-021 Dual High Back Seat Installation, LH, the D350-689-023 Floor Provisions Kit and the D350-689-043 Dual High Back Seat Assembly to IIN-D350-689 Rev. A. The D350-689-021/-023 Kits are compatible with the Energy Attenuating Seat rails in later AS 350/355 model aircraft.

The DSI 9419-011 Kit includes the parts that are required to convert a D350-689-011 installation into a D350-689-021 installation.

PART LIST




-011	-021	-023	-043	P/N	DESCRIPTION
X				DSI 9419-011	ENERGY ATTENUATING CONVERSION KIT
	X			D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
	1	X		D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
	1		X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
			2	D3016-041	SEAT FRAME ASSEMBLY
			1	D3017-041	BACK FRAME ASSEMBLY
	1			D3018-1	SEAT CUSHION
	1			D3019-1	BACK CUSHION
			1	D3021-041	TUBE ASSEMBLY
			1	D3022-1	SEAT PAN
			1	D3023-1	BACK PANEL
			3	D3024-1	SPACER
		1		D3025-1	BEAM
		1		D3026-1	CHANNEL
		1		D3027-1	CLIP
		1		D3027-3	CLIP
		1		D3027-5	CLIP
		4		D3027-7	CLIP
			2	D3031-1	LOOP
1		1		D3234-1	DOUBLER
1		1		D3234-3	DOUBLER
2			2	D3808-041	SEAT RAIL ASSEMBLY
4			4	D3809-1	SLIDING BLOCK
1		1		D3811-041	SEAT TRACK ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: Aug. 19/2008
CERT. NO.: SH02-33
ISSUE NO.: 1

A	NEW ISSUE	RF	08.08.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9419 SHEET 1 OF 5	
APPROVED		TITLE SCALE	
DE APPR.		ENERGY ATTENUATING PROVISION KIT NTS	
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REFERENCE ONLY

-011	-021	-023	-043	P/N	DESCRIPTION
			3	AN3-12A	BOLT
14		14		MS20426AD4-5	RIVET
34		34		MS20470AD4-5	RIVET
7 18		18		MS20470AD4-6	RIVET
		32		MS20470AD5-6	RIVET
			40	MS20600AD4W2	RIVET
			6	MS20600AD4W3	RIVET
/ 9		9	23	MS21042L3	NUT (or MS21042-3)
			4	MS24693-S272	SCREW
/ 8			8	MS24694-S3	SCREW
/ 9		9		MS24694-S50	SCREW
4			4	MS24694-S148	SCREW
			4	MS27039-1-17	SCREW
			12	MS27039-1-19	SCREW
			23	NAS1149D0332J	WASHER (or AN960JD10L)
9		9		NAS1149D0363J	WASHER (or AN960JD10)

PROCEDURE

1. Install the under floor structure as outlined in steps 1-18 of IIN-D350-689 Rev. A and DSI 9311 Rev. A as applicable, except do not install D3032-1 Spacers. Attach D3026-1 Channel to floor using (14) MS20426AD4 rivets. Ensure D3234-1/-3 Doublers are installed per DSI 9269 Rev. A.
2. Position the D3811-041 Seat Track Assy at LBL 27.33 as shown in Figure 1 to be in-line with the existing seat rails at LBL 8.98 and LBL 19.16.
3. Transfer the attachment holes from D3811-041 Seat Track Assy to aircraft floor (9 pls) using a $\phi 0.201$ (#7 drill). Deburr holes. Install D3811-041 using (9) MS24694-S50 screws, (9) NAS1149D0363J washers, and (9) MS21042L3 nuts as shown in Figure 1. Torque screws to 20 to 25 in-lbs (2.3 to 2.8 Nm).
4. If converting a -041 Seat Assembly to a -043 Seat Assembly, remove D3028-1 Studs, D3029-1 Springs, and D3030-1 Locks from the D350-689-041 Seat Assembly. Install (2) D3808-041 Seat Rails Assemblies as shown in Figure 1 Detail A using (4) MS24694-S148 Screws. Torque screws to 100 to 140 in-lbs (11.3 to 15.8 Nm). Install D3809-1 Sliding Blocks using (2) MS24694-S3 screws as shown in Figure 1 Detail A. Torque screws to 12 to 15 in-lbs (1.4 to 1.7 Nm).
5. Remove screws from back end of Seat Tracks at LBL 27.33 and LBL 8.98. Slide D350-689-043 Seat Assembly into both seat tracks and lock in desired position using D3810-1 Retractable Spring Plungers. Re-install screws on back of seat tracks per the Aircraft Maintenance Manual.

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BRANCH
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BY: 
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DATE: Aug. 19/2008
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 2 OF 5
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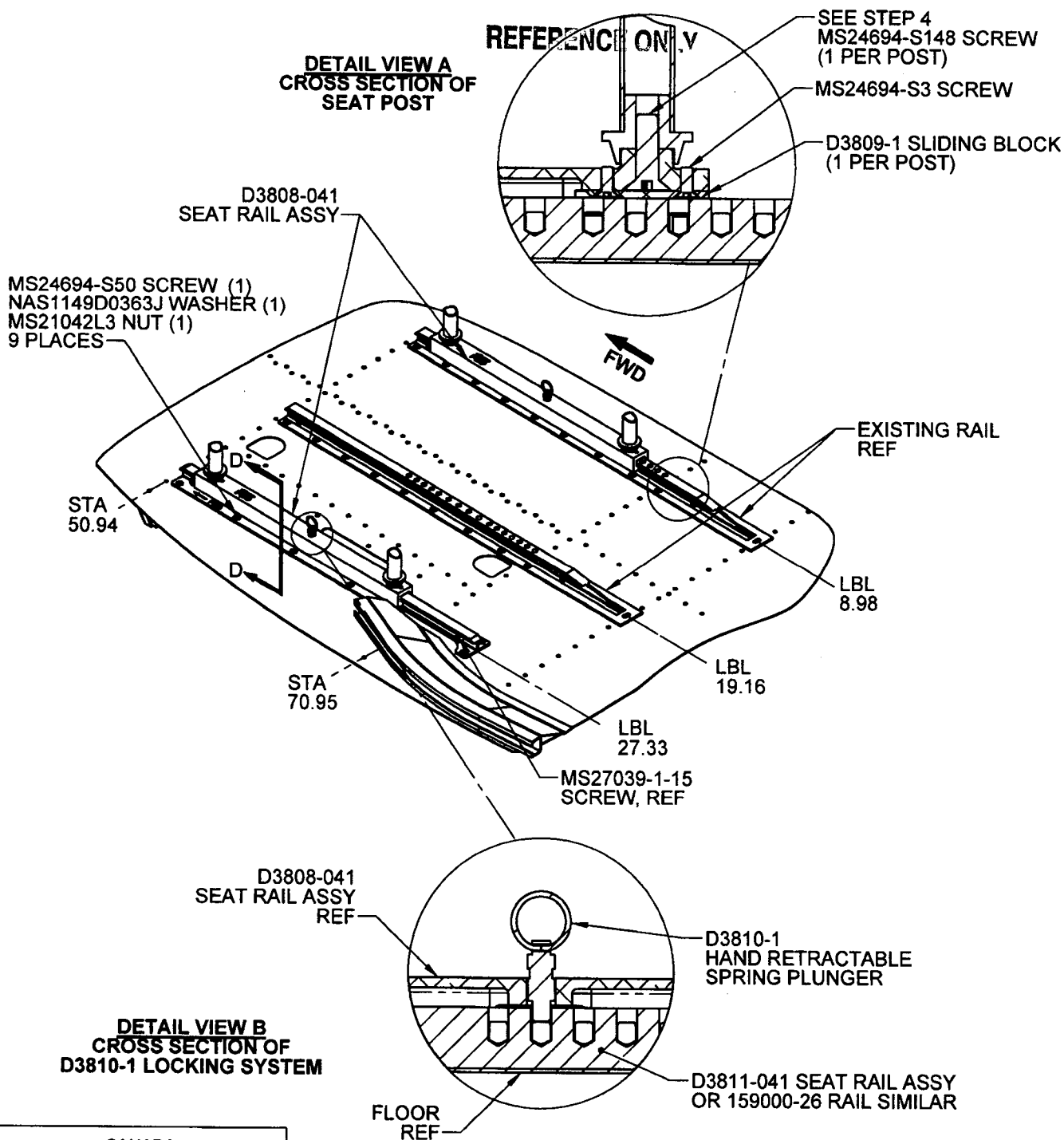


FIGURE 1 D350-689-021 INSTALLATION

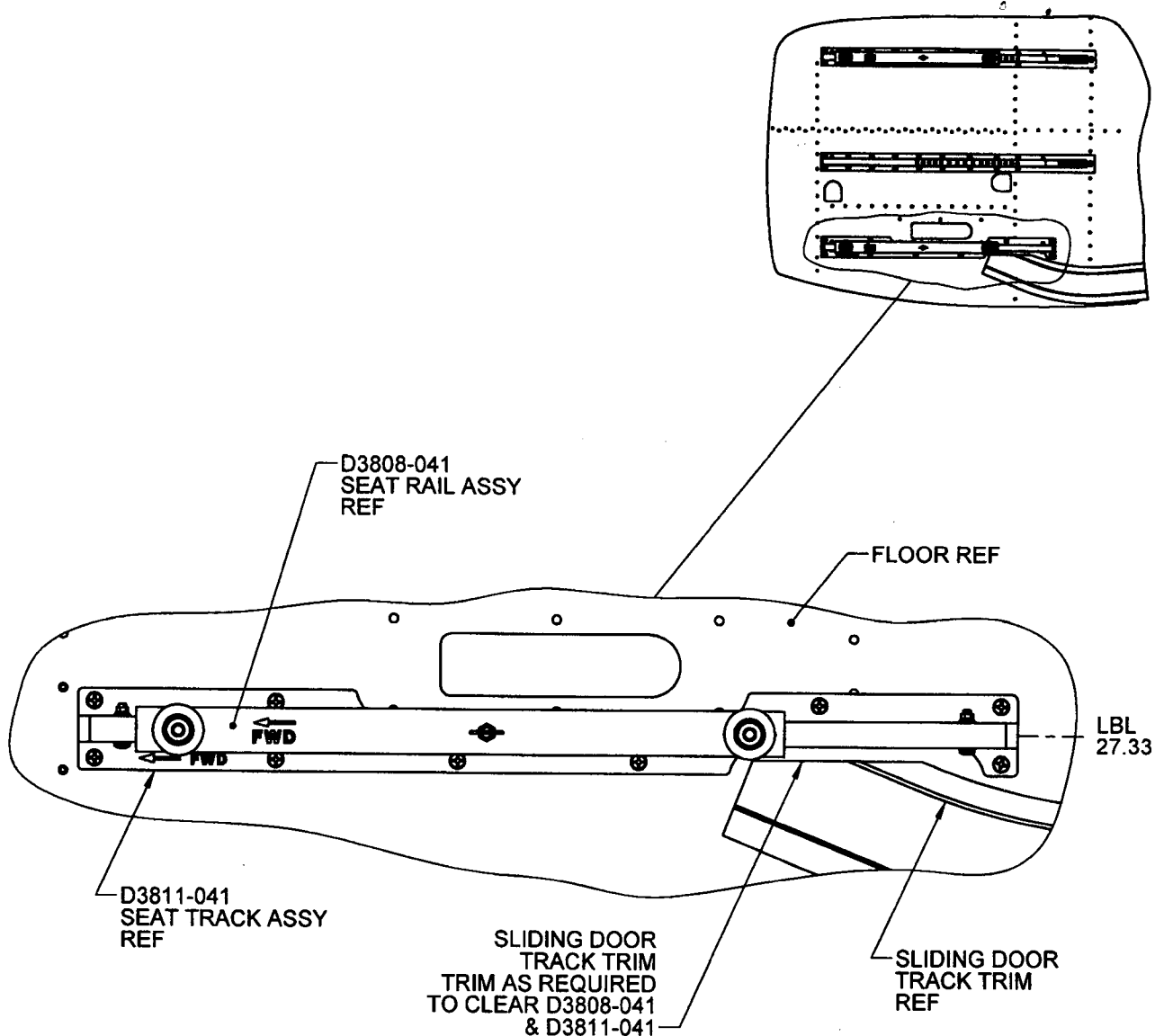
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DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

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CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 3 OF 5
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**DETAIL VIEW C
SLIDING DOOR TRACK TRIM**

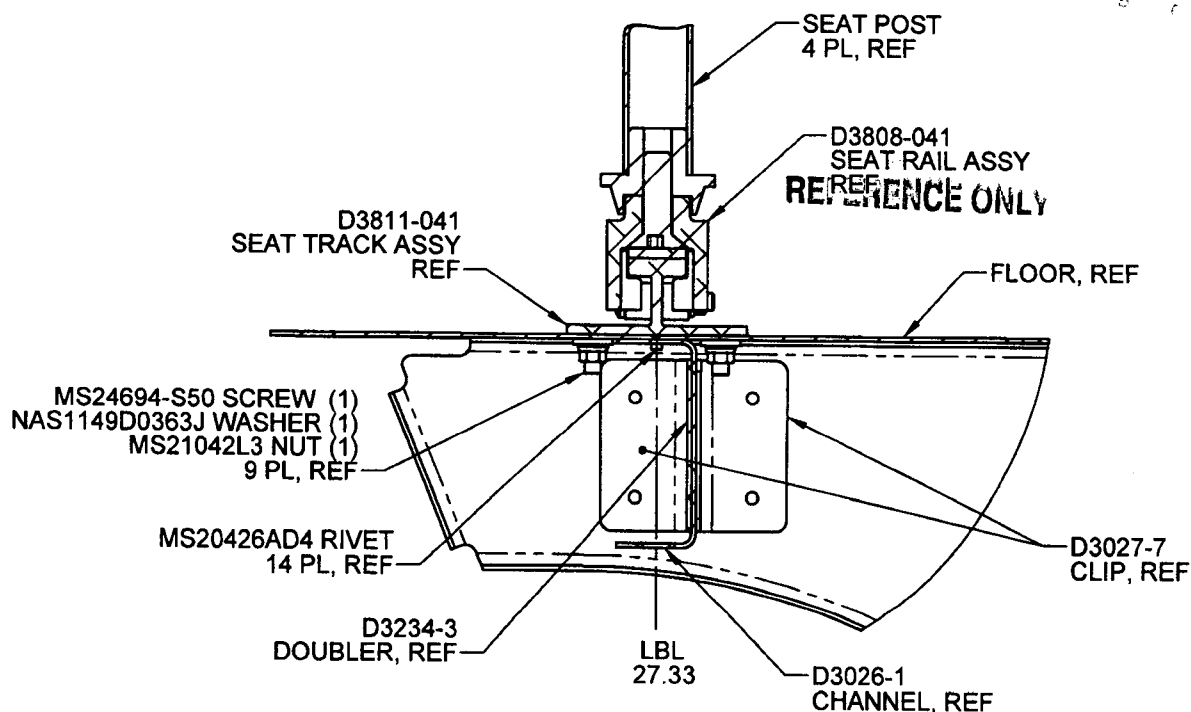
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CHECKED	RF	DRAWING NO. DSI 9419	REV. A
MFG. APPR.	N/A		SHEET 4 OF 5
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CROSS SECTION D-D

WEIGHT AND BALANCE

The following is the net weight increase associated with the Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9419-011 Energy Attenuating Conversion Kit	1.1 lb 0.50 kg	-18.2 in -0.46 m	-20 in-lb -0.2 m-k-g	60.7 in 1.54 m	67 in-lb 0.77 m-k-g
D350-689-021 Dual High Back Seat Installation, LH Fwd Position	28.6 lb 13.0 kg	-18.2 in -0.46 m	-521 in-lb -6.0 m-k-g	60.7 in 1.54 m	1736 in-lb 20.0 m-k-g
D350-689-021 Dual High Back Seat Installation, LH Aft Position	28.6 lb 13.0 kg	-18.2 in -0.46 m	-521 in-lb -6.0 m-k-g	64.7 in 1.64 m	1850 in-lb 21.3 m-k-g
D350-689-023 Energy Attenuating Floor Provisions Kit	2.5 lb 1.1 kg	-18.2 in -0.46 m	-46 in-lb -0.5 m-k-g	62.2 in 1.58 m	156 in-lb 1.7 m-k-g

REVISED LOADING CHART




With respect to the Loading Chart in FMS-D350-689, when the Dual High Back Seat has been installed in an aircraft with Energy Attenuating Seat rails per this DSI, the occupants are located at STA 61.02 when the seat is in the Fwd position and at STA 65.02 when the seat is in the Aft position.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: 
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 5 OF 5
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Status	Item ID	Rev	Name	Start Date	Quantity	Pe	UOM	Scrap %	Route Seq	II	Sort	Comments	Date Last Mod	Stop Date
	AN960JD10		Washer	1/1/2008	9.0000		Each	0 %	110		0	a	12/5/2009 7:...	
	D3234-1		Doubler	12/5/2009	1.0000		Each	0 %	110		0	a	12/5/2009 8:...	
	D3234-3		Doubler	12/5/2009	1.0000		Each	0 %	110		0	a	12/5/2009 8:...	
	D3808-041		Seat Rail Assembly	12/5/2009	2.0000		Each	0 %	110		0	a	12/5/2009 8:...	
	D3809-1		Sliding Block	12/5/2009	4.0000		Each	0 %	110		0	a	12/5/2009 8:...	
	D3811-041		Seat Track Assembly	12/5/2009	1.0000		Each	0 %	110		0	a	12/5/2009 8:...	
	MS20426AD4-5		Rivet	1/1/2008	14.0000		Each	0 %	110		0	a	12/5/2009 7:...	
	MS20470AD4-5		Rivet, Universal Head	1/1/2008	34.0000		Each	0 %	110		0	a	12/5/2009 7:...	
	MS20470AD4-6		Rivet, Universal Head	1/1/2008	18.0000		Each	0 %	110		0	a	12/5/2009 7:...	
	MS21042L3		Nut	1/1/2008	9.0000		Each	0 %	110		0	a	12/5/2009 7:...	
	MS24694-S148		Screw	11/29/2011	4.0000		Each	0 %	110		0	a		
	MS24694-S3		Screw	1/1/2008	8.0000		Each	0 %	110		0	a	12/5/2009 7:...	
	MS24694-S50		Screw	1/1/2008	9.0000		Each	0 %	110		0	a	12/5/2009 7:...	